

NCP-19-7434



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5637-1

Job Sheet 197996



Part No: D5637-1

Job Qty: 4 pcs

Part Name: Web



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5637 REV.A IPP REV:A 19.05.30 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	4 pcs	8/9/19		0.00	2.00	Skidtubes - 1		MJE
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	4 pcs	8/9/19		0.00	0.00	QC 5 - 10		BE
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Handfinish - 1-1 Chemical-B4B	4 pcs	8/9/19		0.00	0.80	Handfinish - 1 - 1 - B4B		SEP 05 2019
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		



Container No: S211325



Part: D5637-1

Job No: 197996

Serial No/Batch: S211325

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: smles@dartaero.com
www.dartaerospace.com

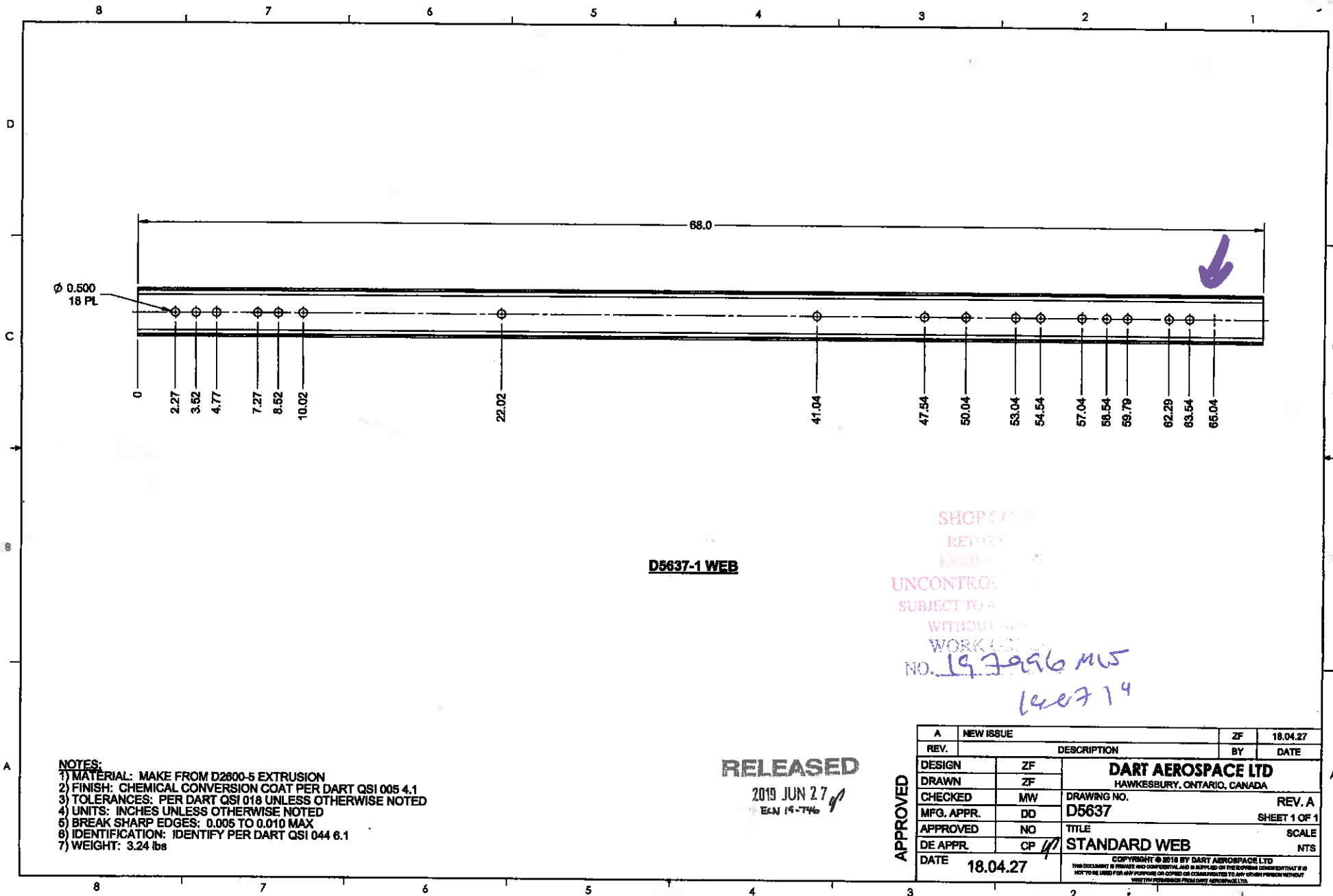
Date: 09/04/19

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					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
130 QC 7	4 pcs	8/9/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	M/S
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
160 Packaging 3-1 - Stock - B4B	4 pcs	8/9/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	TF
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DMS
170 QC 21 - SA	4 pcs	8/9/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89
Part Op 100 - 1- CUT WEB TO LENGHT AS PER DWG AND DEBURR. 2- DRILL HOLES IN D5637-1 AS PER DWG (USE Descriptions: DT10540) 3- OPEN HOLES TO SIZE AS PER DWG , DEBURR. 110 - QC5- Inspect part completeness to step on W/O 120 - CHEMICAL CONVERSION COAT WEB 130 - QC7-Inspect Chemical Conversion Coat 160 - Identify as per dwg & Stock Location: <u>LG002</u> 170 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2600-5-108	Extrusion I-Beam Thin	4 pcs (1 ea)	100-Skidtubes - 1	<u>S146203</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Skidtubes - 1	D2600-5-108	4	178	0	
Part Specifications					
Specifications could not be found.					

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D5637-1 WEB

SHOP COPY
RETURN
UNCONTROLLED
SUBJECT TO A
WITHOUT A
WORK ORDER
NO. 197996 MW
140714

NOTES:

- 1) MATERIAL: MAKE FROM D2800-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 3.24 lbs

RELEASED

2019 JUN 27

ECN 19-746

APPROVED

A NEW ISSUE		ZF 18.04.27	
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	18.04.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5637** REV. A
SHEET 1 OF 1
TITLE **STANDARD WEB** SCALE NTS

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DT10540

DART AEROSPACE LTD		Work Order:	197996
Description: STANDARD web		Part Number:	D5637-1
Inspection Dwg: D5637 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.27	0.030	2.270			CALIPER	
3.52	0.030	3.524			CALIPER	
4.77	0.030	4.771			CALIPER	
7.27	0.030	7.267			CALIPER	
8.52	0.030	8.518			CALIPER	
10.02	0.030	10.016			CALIPER	
22.02	0.030	22.010			TAPE	
41.04	0.030	41.041			TAPE	
47.54	0.030	47.541			TAPE	
50.04	0.030	50.041			TAPE	
53.04	0.030	53.041			TAPE	
54.54	0.030	54.541			TAPE	
57.04	0.030	57.041			TAPE	
58.54	0.030	58.541			TAPE	
59.79	0.030	59.791			TAPE	
62.29	0.030	62.291			TAPE	
63.54	0.030	63.541			TAPE	

Measured by: MLG	Audited by: TW	Preliminary Approval:
Date: 4 Sept 2019	Date: 18-09-04	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15

7R Date: Oct 21/19

Date:

Oct 21/19



NCR No.

19-7434

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>197966</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>05637-1</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐
Date: <u>19-09-03</u>		Sequence #:		QTY Affected: <u>4</u>		MRB (QSI042)	
Description Work Order Deviation				Disposition			
Dwg shows 18 PL Ø 0.500 holes. Hole at 65.04 not shown in dwg				Do not drill hole at 65.04. Dwg should say 17 PL			
				Completed By <u>JW</u> <u>17-10-7</u>			
				Lead hand / Supervisor <u>JW</u> <u>19-10-7</u>			
				QC / QA Coordinator <u>DAS</u> <u>68</u> <u>9-89</u> <u>OCT 09 2019</u>			
Root Cause		FAULT CATEGORY					
Operator ☐		☐ Pressure/Forced		☐ Contamination		☐ Power Loss/Surge	
Manufacturing Process ☒		☐ Bending		☐ Misaligned/off center		☐ Folio/Program	
Equip/Tooling ☐		☐ Crushing		☐ BOM/Route		☐ Grain Direction	
Handling/Preservation ☐		☐ Cracks		☐ Broken/Damage/Defect		☒ Drawing	
Material ☐		☐ Crimp/Kink/Ripple/Wave/Twist		☐ Incomplete/Unclear Instructions		☐ Finish	
Product Improvement ☐		☐ Marks/Chatter		☐ Drill Holes		☐ Part Lost/Missing	
Process Improvement ☐		☐ Mislabeled		☐ Fit/Function		☐ Misread	
Human Factors ☐		Other/Details:					